

Basis	Temperature resistant reinforcing paste
Resin	PS 07-1
Hardener	TM
Colour	alu grey

Applications

- Vacuum forming tools
- Press tools
- Prepreg tool
- Polyester press tool
- Adhesive probes

Properties

- heat resistant
- glassfibre filled
- aluminium filled

Processing data

Product		Mixture PS 07-1 / TM	Resin PS 07-1	Hardener TM
Colour		alu grey	alu grey	brown transparent
Mixing ratio	p. b. w.		100	6
Viscosity at 25°C	mPas	pasty	pasty	375 ± 75
Density at 20°C	g / cm ³	1,90 ± 0,08	2,00 ± 0,08	0,97 ± 0,02
Pot life 200 g / 20°C	min.	70 - 80	-	-
Curing time at RT	hrs.	24 - 36	-	-
Post curing	Time in h/ Temperature in °C	post curing required	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	23 ± 4
Flexural modulus	EN ISO 178	MPa	4250 ± 800
Flexural strength at breakage	EN ISO 178	%	0,8 ± 0,2
Compressive strength	EN ISO 604	MPa	52 ± 4
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	5 ± 1
Heat resistance (Martens)	DIN 53458	°C	158 ± 3
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-

Sales units (packages)

Units	Resin	PS 07-1	25,000 kg
	Hardener	TM	1,500 kg / 8,000 kg

Processing instructions

The mixing of the glass fiber and aluminium particle filled reinforcing paste PS 07 with the hardener TM should be made in a mechanical kneader. Smaller quantities can also be mixed with a spiral stirrer in a hand drilling gun or by hand.

The mixed paste should be applied directly on the fresh surface layer or on the coupling layer KP 7-1/TM and should be well compressed.

Heating and cooling coils can be inserted into the paste.

In General

ebalta PS 07/TM is an aluminium- and glass fiber consisting, temperature-resistant two-component-epoxy paste, which precures at room temperature and can be used up to 150°C after heat treatment.

At room temperature the system is completely cured only after 7 days and can only be used up to 60°C.

A high heat resistance will be reached by the below mentioned step by step postcuring (ca. 20 °C /hrs).

Glass transition temperature (TG) 95 °C: After post curing 4 hrs at 40 ° C until 10 hrs at 60 °C

Glass transition temperature (TG) 139°C: After post curing 4 hrs at 40 ° C until 10 hrs at 60 °C + 4 hrs at 100 °C

Glass transition temperature (TG) 139°C: After post curing 4 hrs at 40 ° C until 10 hrs at 60 °C + 4 hrs at 100 °C + 4 hrs at 135 °C

A slow cooling down to room temperature is necessary. It would be to execute the complete post-curing, at least the first post-curing operation, on the master model.

ebalta PS 07-1/TM can be applied approx. 30-40 mm thick in one operation.

Storing

At appropriate storage (room temperature) in closed original container 12 months. Occuring crystallization due to unfavourable storage conditions can be neutralized by warming up the material at approx. 60° C.

Already opened containers should be closed immediately after use and be protected against moisture. This material should be used as soon as possible.

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.

Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.

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